

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019744**Date Inspected:** 06-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 14, OBG (NWIT # 7642)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SEG3009K-117, 118

SEG3009L-253~257

BAY 14, OBG (NWIT # 7644)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SEG3019AB-091~096

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

BAY 14, OBG (NWIT # 7656)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SEG3013K-001, 002

SEG3013L-001 (UT class "A" rejectable indication found during inspection)

During Ultrasonic Testing of weld joint SEG3013L-001, one class "A" UT rejectable indication observed and confirmed with ZPMC NDT personnel. This issue has been discussed with CT lead QA and as per discussion no Incident Report to be generated. ZPMC agreed to do repair as comply to contract documents.

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 14

SEGMENT 13AW

Welding by FCAW process of weld joint SEG3013Y-339 joining Floor Beam (FB) to Sub Assembly (SA) at Panel Point (PP) 119 of segment 13AW. Welder is identified as 066439. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

Welding by FCAW process of weld joint SEG3013P-114, 115 joining I-rib stiffener of Floor Beam at Panel Point (PP) 118 of segment 13AW. Welder is identified as 045240. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

Welding by FCAW process of weld joint SEG3013H-003 of segment 13AW. Welder is identified as 066421. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

Welding by FCAW process of weld joint SEG3013F-004 of segment 13AW. Welder is identified as 068445. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

Welding by FCAW process of weld joint SEG3013K-026 of segment 13AW. Welder is identified as 066439. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
